

NOTICE: THE INFORMATION AND  
DESIGN CONTAINED HEREIN IS THE  
PROPERTY OF PREMIER AVIATION  
WHO RESERVES ALL RIGHTS THERETO

NOTES (UNLESS OTHERWISE SPECIFIED):

1. IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURE, 115-12112 (PARA. 2.1/2.2).
2. REMOVE ALL BURRS, BREAK ALL EDGES/CORNERS .015-.25 RAD, EXCEPT AS NOTED.
3. PRIME SHEET METAL PARTS WITH MIL-P-23377 EPOXY PRIMER OR TT-P-1757 ZINC CHROMATE PRIMER OR EQUIV.
4. GENERAL SHOP PRACTICES FOLLOW PREMIER SPEC 008-93000 AND/OR AC43.13.

- △ MAKE PARTS PER TEMPLATE. SEE CHART BELOW. TOOL IS TO BE MARKED WITH PART # AND A "T" AT THE END.  
EXAMPLE: BXX-XXXX-XXT  
ALL PARTS MADE FROM TEMPLATES, TOOLS, OR MOLDS TO BE FITTED TO TRIM LINES.

PART #	TOOL #	PART #	TOOL #	PART #	TOOL #
-09	-09T	-209	-209T	-220	-220T
-15	-15T	-211	-211T	-221	-221T
-21	-21T	-213	-213T	-291	-291T
-137	-137T	-214	-214T	-293	-293T
-147	-147T	-215	-215T	-295	-295T
-163	-163T	-217	-217T	-297	-297T
-179	-179T	-219	-219T	-305	-305T

- 6 MAKE PARTS PER ASSEMBLY TEMPLATE. SEE CHART BELOW. TOOL IS TO BE MARKED WITH PART # AND AN "AT" AT THE END.  
EXAMPLE: BXX-XXXX-XXAT

ASSEMBLY TOOL #
-01AT
-03AT
-05AT
-07AT

7. WELD PARTS PER MIL-W-8604/ MIL-STD-2219. (ALUM)

- 8 CADMIUM PLATE PER QQ-P-416F. CLASS2. TYPE2.

- 9 UPHOLSTERY / FINISH PER CUSTOMER SPECIFICATION  
TO MEET FAR 29.853(a)(2).

- 10 STITCHING PER FED-STD-751.

- 11 MAKE PARTS PER ROUTE TEMPLATE. SEE CHART BELOW, TOOL IS TO BE MARKED WITH PART # AND AN "RTX" AT THE END.  
EXAMPLE: BXX-XXXX-XXRTX

ROUTE TOOL #
-217RTA
-217RTB
-217RTC
-217RTD

- 12 ALTERNATE: 430-34057-21 CLEAT(SFENA).


- 13 ALTERNATE FINISH: PRIME SHEET METAL PARTS WITH MIL-P-23377 EPOXY

REV STATUS OF SHEETS	REV SHEET	B	A	A	A	A	A	A	A	A	A	-	A	B	B	A	A	A	A	A	A	-	A	A	A
		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24

REVISIONS				
ZONE	MOD	REV	DATE	APPROV
		-	MFG. RELEASE	11/08/93 <i>FWW</i>
		A	REVISED PER ECO 3893	11/12/93 <i>FWW</i>
		B	REVISED PER ECO 3910	11/30/93 <i>Joe</i>

										-61	OPEN			
										-59	OPEN			
										-57	OPEN			
										-55	OPEN			
									1	-53	PIVOT ASSY			
								1		-51	PIVOT ASSY			
							2			-49	END BLOCK ASSY			
								2		-47	PIPE ASSY			
								2		-45	PIVOT ASSY			
										-43	PIVOT ASSY			
								2		-42	ROLLER ASSY (OPP -41)			
								2		-41	ROLLER ASSY			
								1		-39	HEADREST ASSY			
									1	-37	BRKT ASSY			
									2	-35	HANDLE ASSY			
									1	-33	HANDLE ASSY			
										-31	GUIDE ASSY			
										-29	GUIDE ASSY			
										-27	GUIDE ASSY			
									2	-25	PIVOT ARM ASSY			
										-23	PIVOT ASSY			
									1	-21	KLEGECELL ASSY			
									4	-19	FOOT MOD			
									1	-17	PLATE ASSY			
									1	-15	COMPOSITE BASE ASSY			
										-13	RESTRAINT ASSY			
									1	-11	LATCH ASSY			
										-09	PAD ASSY			
										-07	STRETCHER ASSY			
										-05	BASE ASSY			
										-03	PAN ASSY			
										-01	LITTER ASSY			

[illegible]

MATERIAL	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ON		DRAWN	DL KREMPIN	DATE	11/02/93	 <b>PREMIER</b>	PREMIER AVIATION
	DECIMALS .XX±.05 .XXX±.03 ANGLES ±1°		CHECKED					GRAND PRAIRIE, TEXAS
FINISH LAST SECTION LETTER USED "J"	ON	NHA	APPROVAL				LITTER ASSY/DETAILS	
	412		RELEASED	<i>[Signature]</i>	11/08/93			
			APPROVAL					
			APPROVAL					
			SIZE CODE IDENT NO.		D 0SUV8		B89-23000	REV
			SCALE:		WT:		SHEET	OF

STC'd PRINT 2 B8923000.01

# ORIGINAL

MS2928HS JIS SH8767SW

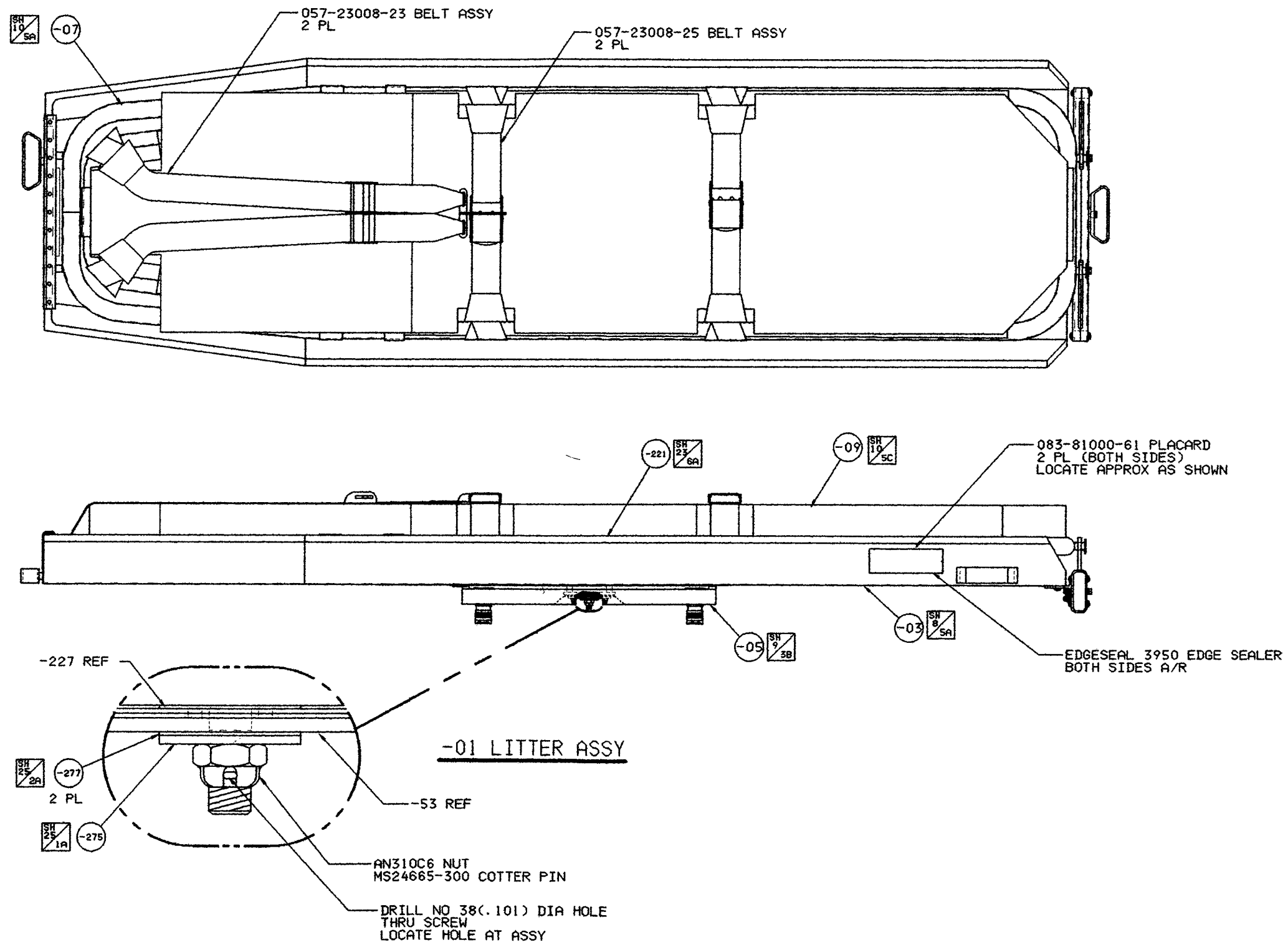




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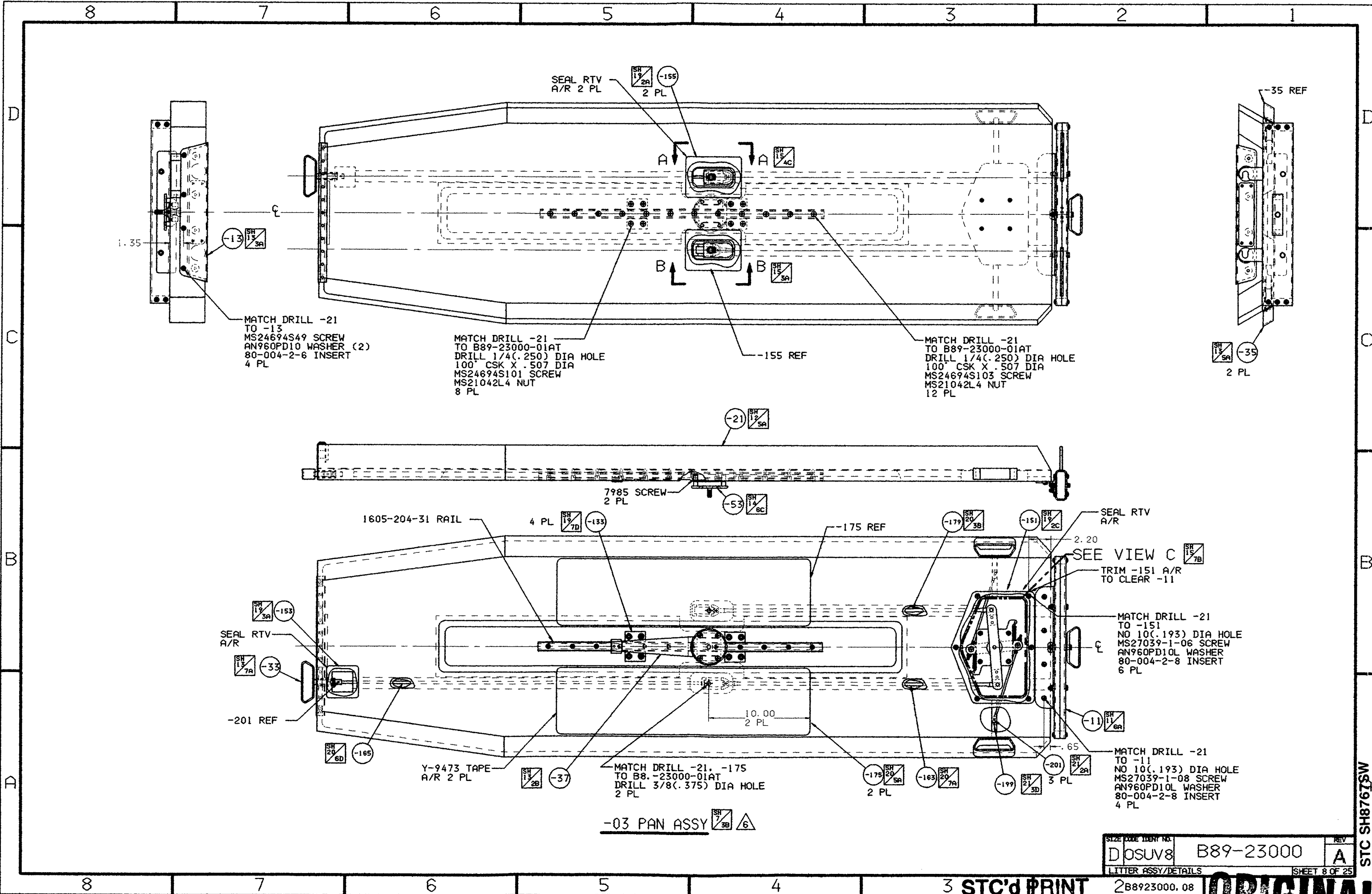
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LITTER ASSY/DETAILS			SHEET 7 OF 25

STC'd PRINT

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ORIGINAL

STC SH8767SW



SIZE CODE IDENT NO.	REV
D OSUV8	B89-23000
LITTER ASSY/DETAILS	A
SHEET 8 OF 25	

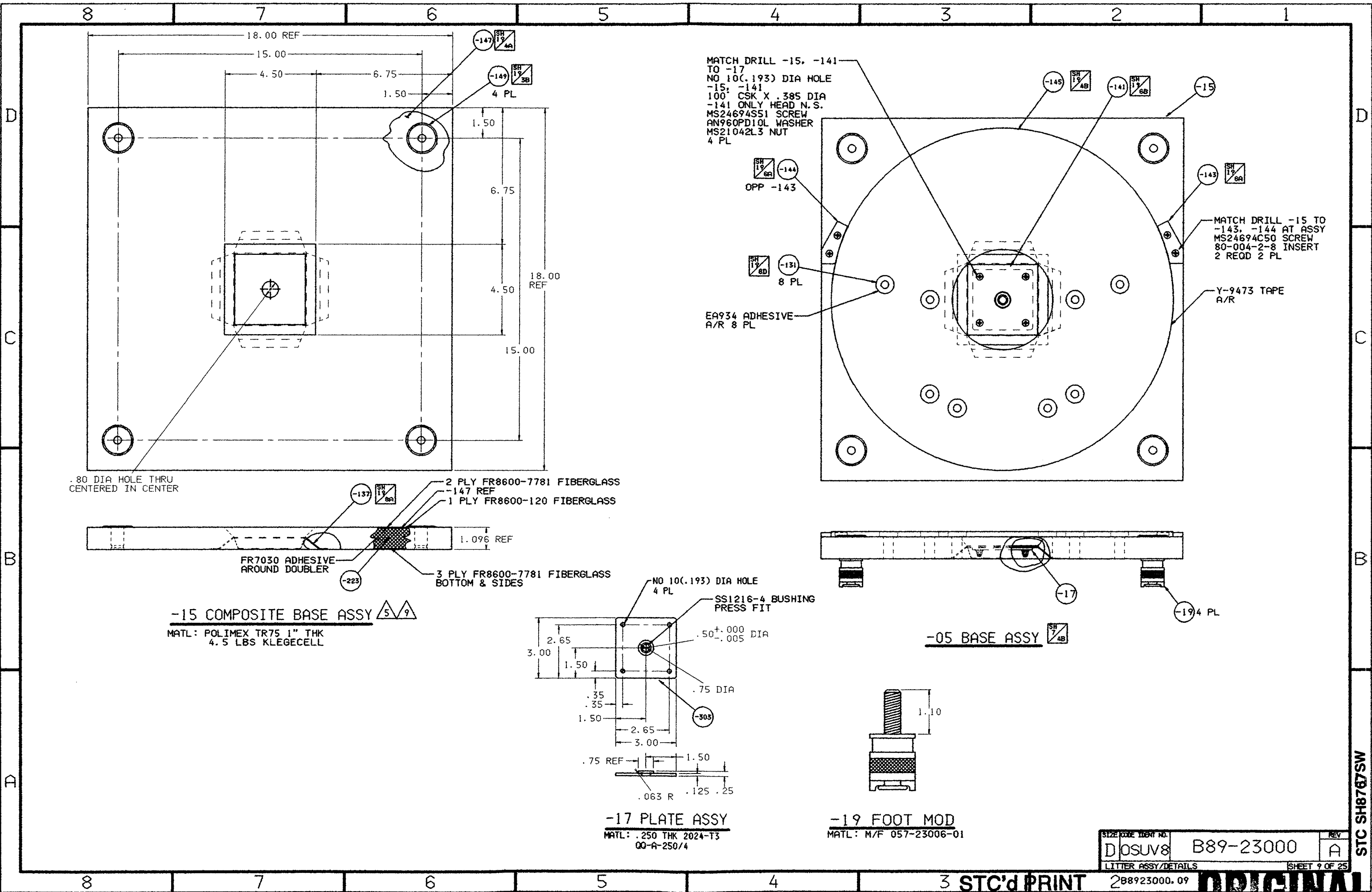
STC'd PRINT

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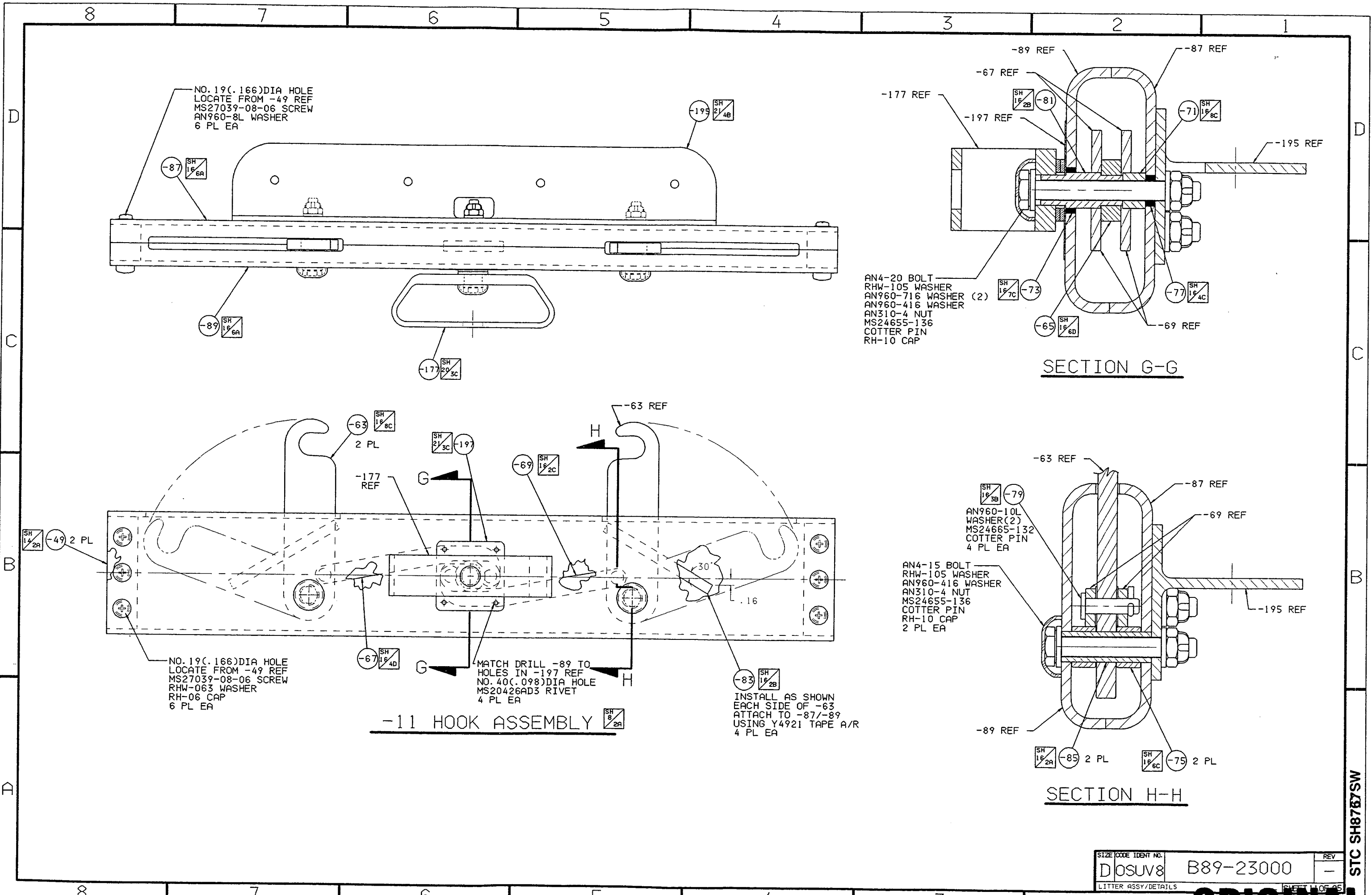
ORIGINAL

STC SH8767SW









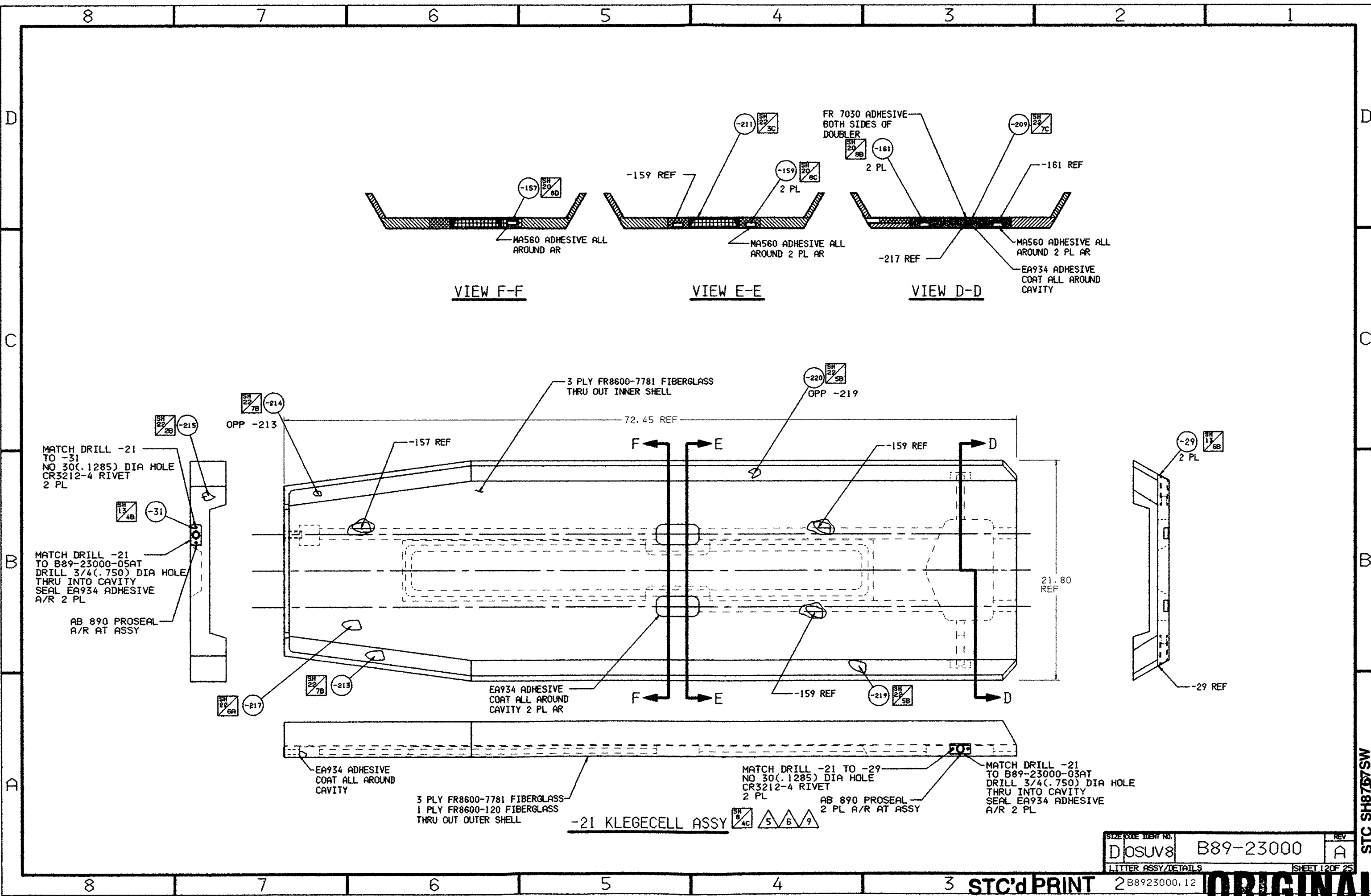
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LITTER ASSY/DETAILS		SHEET 1 OF 05	

STC'd PRINT

2B8923000.11

ORIGINAL

STC SH8787SW



SIZE/FILE IDENT NO.	B89-23000	REV	A
LITTER ASSY/DETAILS			
SHEET 12 OF 25			

STC'd PRINT

2 B8923000.12

ORIGINAL

STC SH8767SW



SH 24 6D -235  
SH 24 6D -236  
OPP -235  
MS24694S110 SCREW  
MS21044-N4 NUT

-41 ROLLER ASSY  
-42 ROLLER ASSY (OPP -41)

1651-214-10 BEARING

MS24964C192 SCREW

MS24694S101 SCREW  
MS21042L4 NUT  
4 PL

-53 PIVOT ASSY

MATCH DRILL -269 TO  
-257 THIS SIDE ONLY  
3/8(.375) DIA HOLE

-43 PIVOT ASSY

-45 PIVOT ASSY

MATCH DRILL --271 TO -249  
1/8(.125) DIA HOLE  
NAS607-2-16 PIN  
2 PL

-51 PIVOT ASSY

SH 25 7B -287  
SH 25 5C -285  
SH 24 2A -259  
SH 24 4B -251  
SH 25 5B -301  
NAS607-1-4 PIN  
2 PL  
MS24665-170  
COTTER PIN  
2 PL  
E0180-022-0500  
SPRING

WELD INSIDE DIA  
ONLY 1/2 AROUND  
2 PL

-39 HEADREST ASSY

-47 PIPE ASSY

INSTALL MS21209-C0825  
HELICOIL INSERT  
6 PL

-49 END BLOCK ASSY

MATL: 1.00 THK 6061-T6511  
QQ-A-200/8

SIZE	CODE	IDENT NO.	REV
D	OSUV8	B89-23000	B
LITTER ASSY/DETAILS			SHEET 14 OF 25

STC'd PRINT

2B8923000, 14

ORIGINAL

NS/SH8767SW

8 7 6 5 4 3 2 1

D

D

C

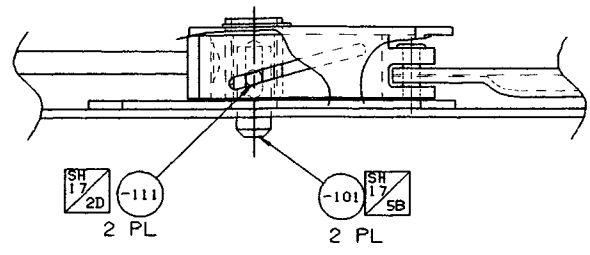
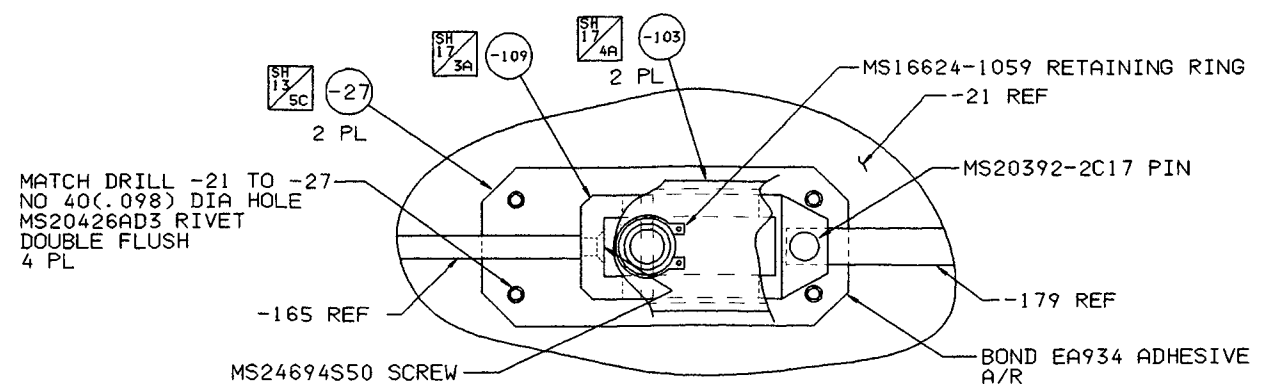
C

B

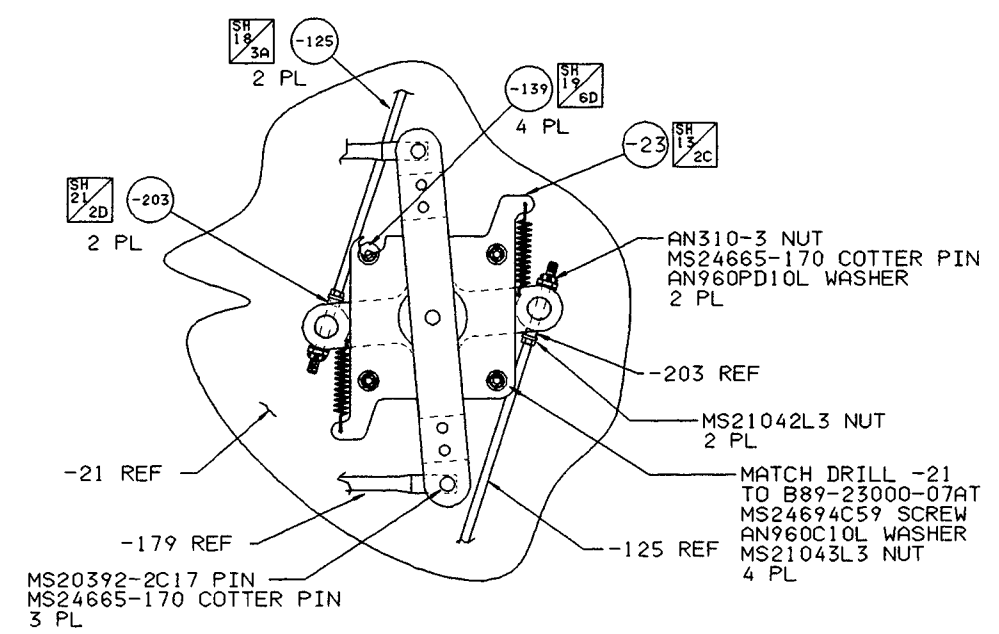
B

A

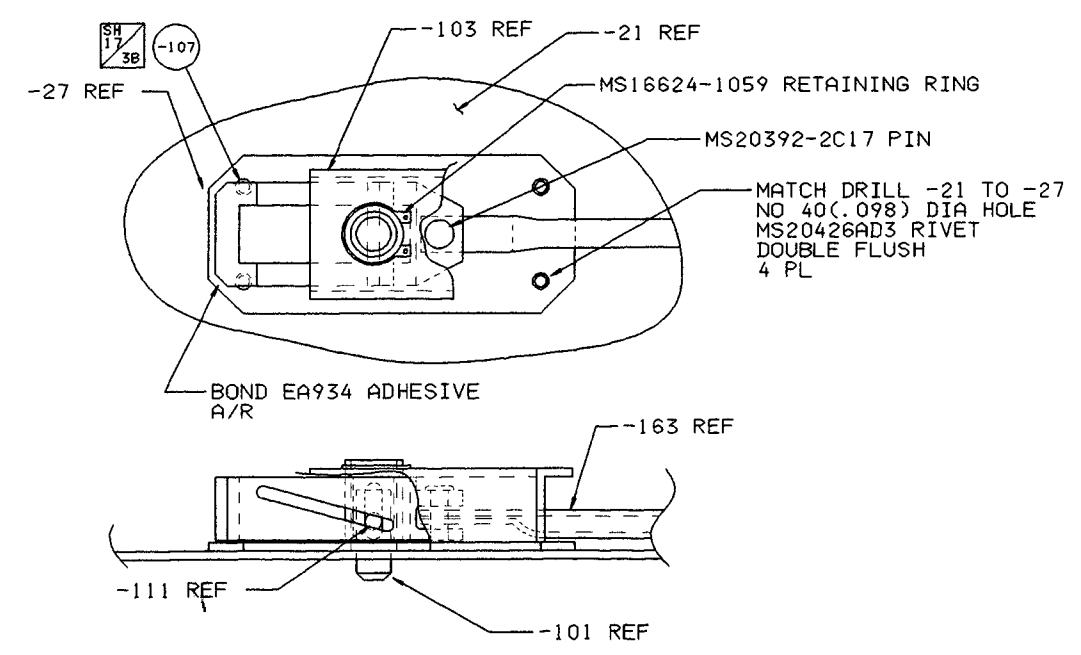
A



VIEW A-A



VIEW C



VIEW B-B

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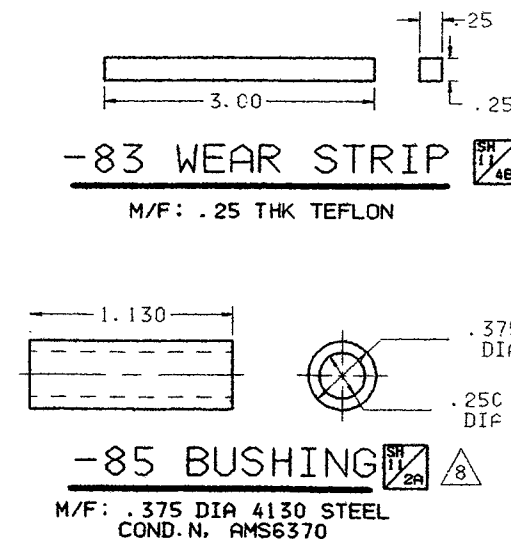
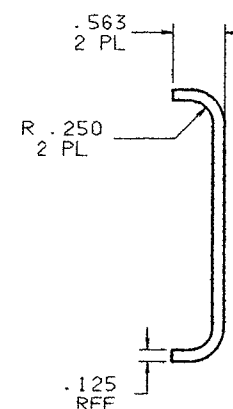
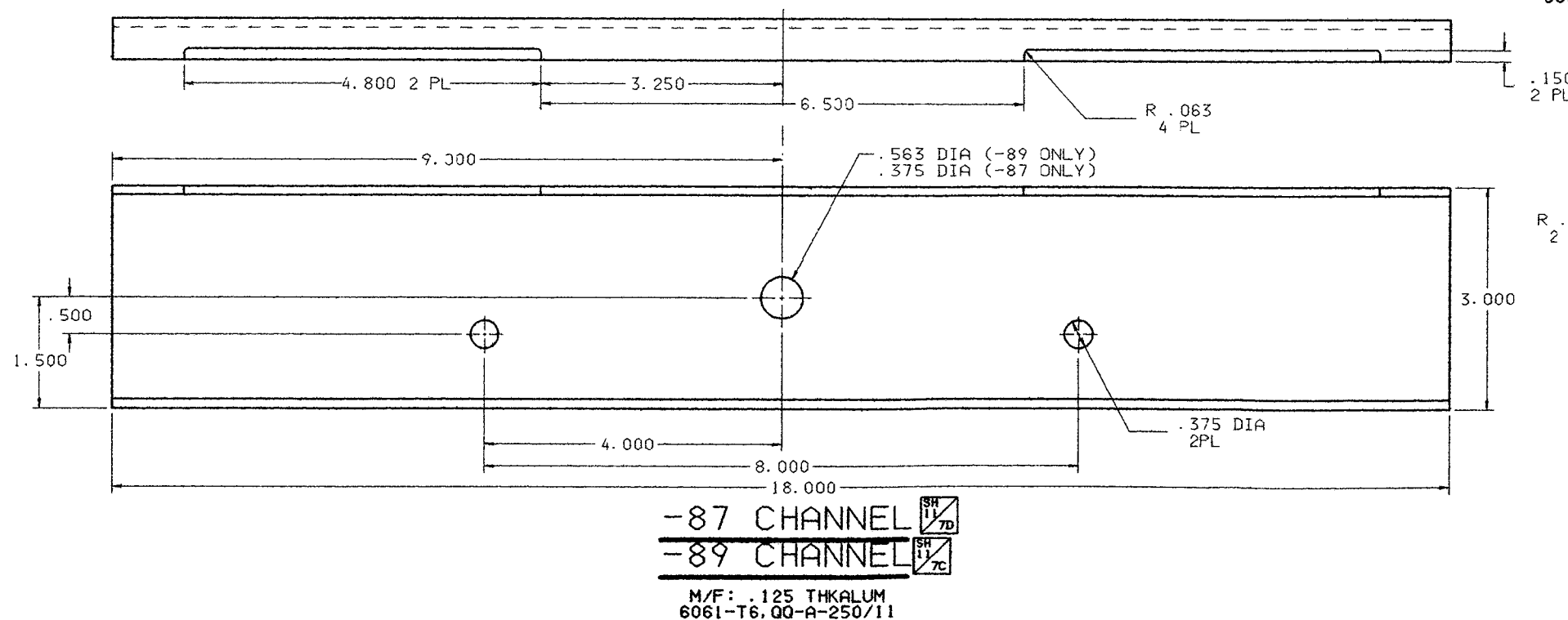
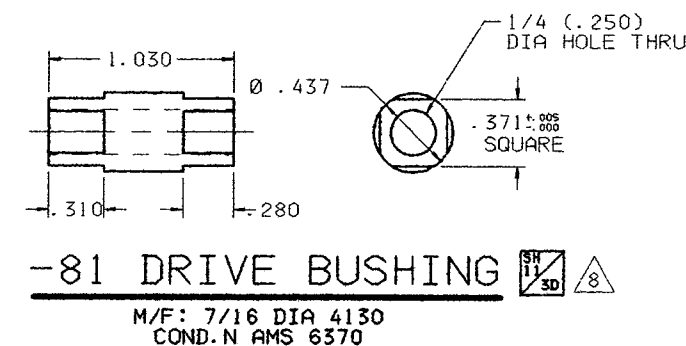
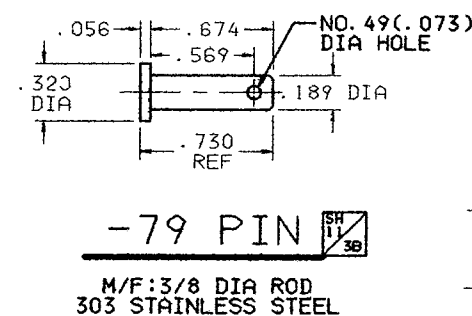
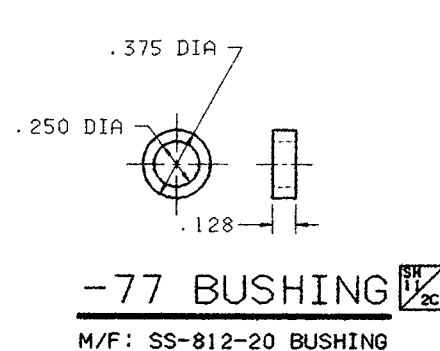
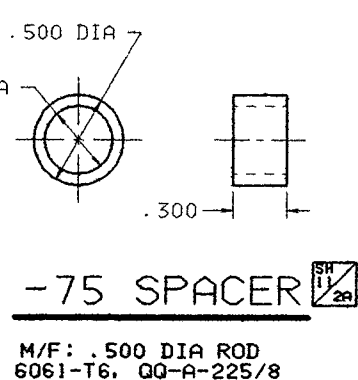
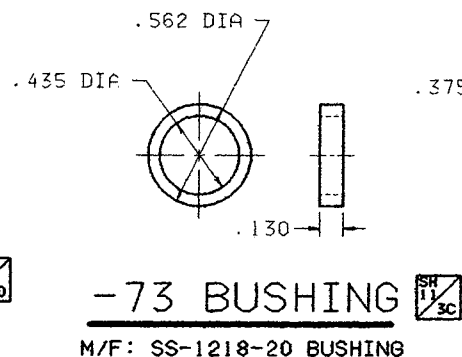
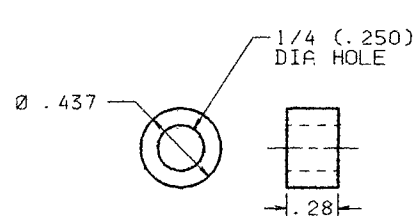
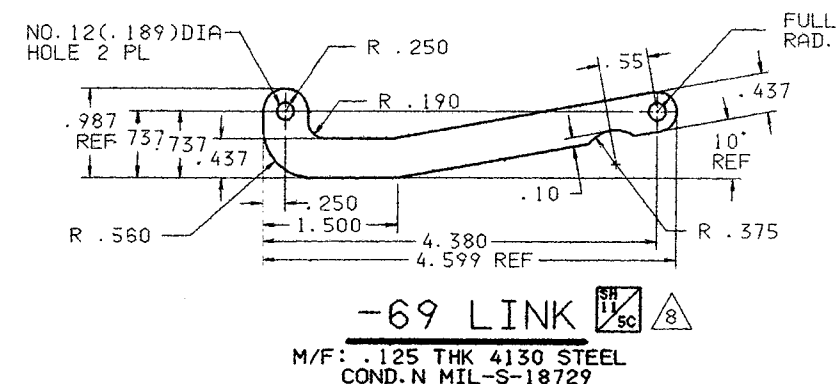
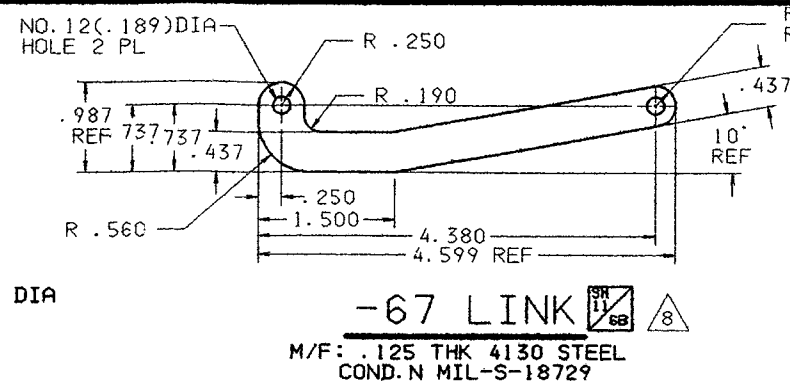
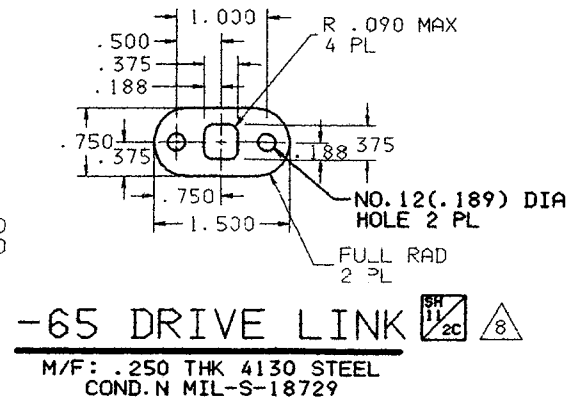
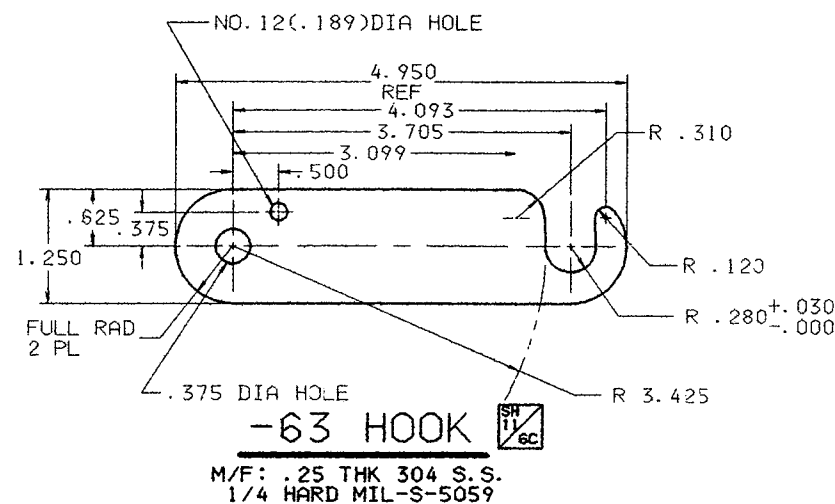
SIZE CODE IDENT NO.	REV
D OSUV8	A
LITTER ASSY/DETAILS	SHEET 15 OF 25

STC'd PRINT

2 B8923000, 15

ORIGINAL

STC SH8767SW



SIZE	CODE	IDENT NO.	REV
D	OSUV8	B89-23000	A
LITTER ASSY/DETAILS			SHEET 18 OF 25

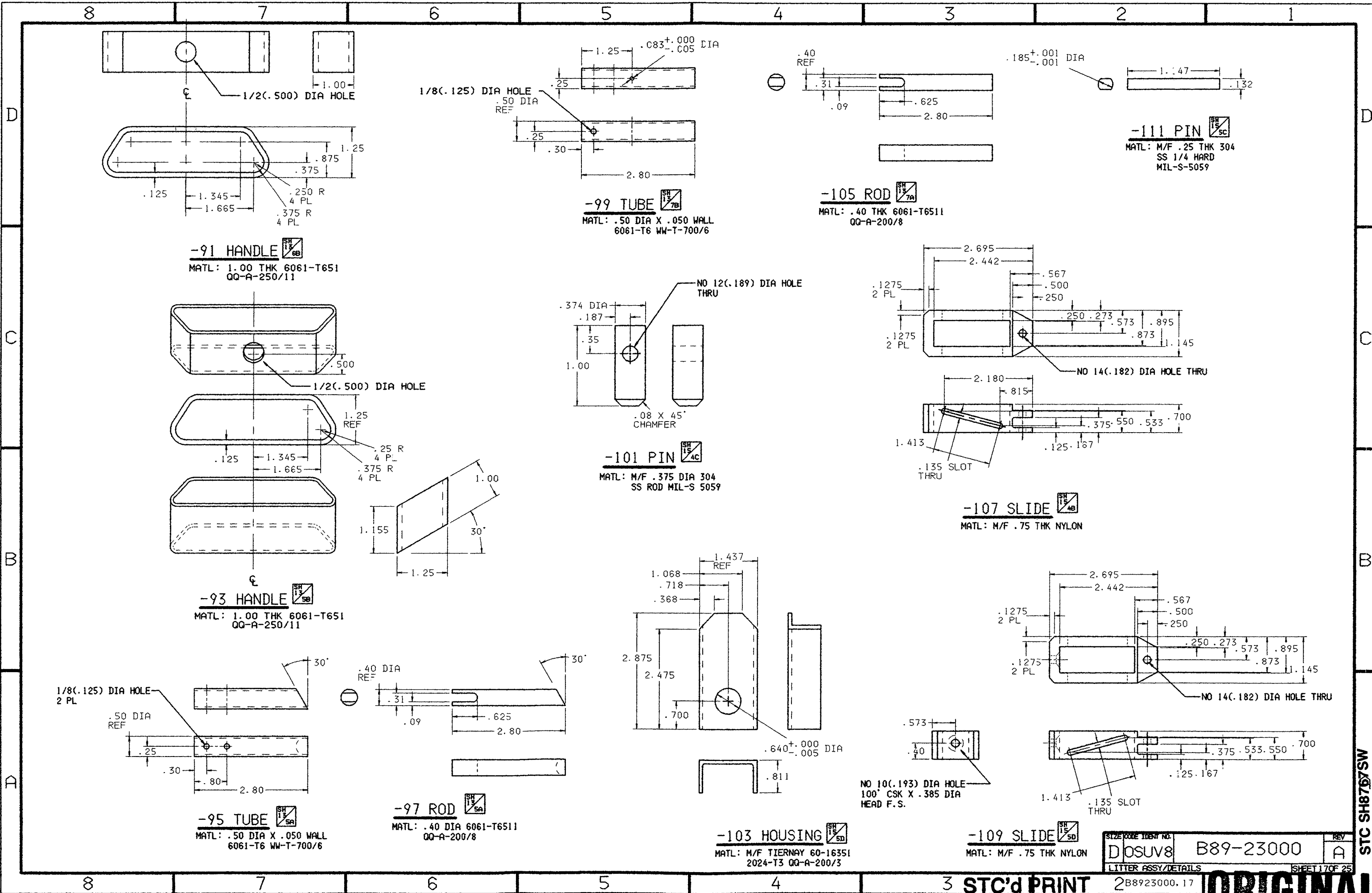
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2 B8923000, 16

ORIGINAL

STC SH876ZSW





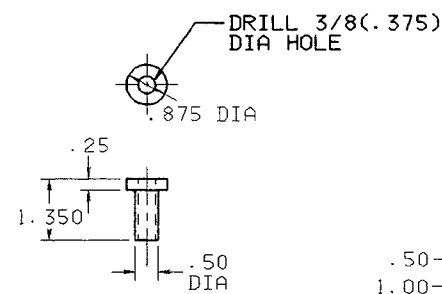
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B89-23000	
LITTER ASSY/DETAILS	
SHEET 17 OF 25	

STC'd PRINT 2B8923000.17

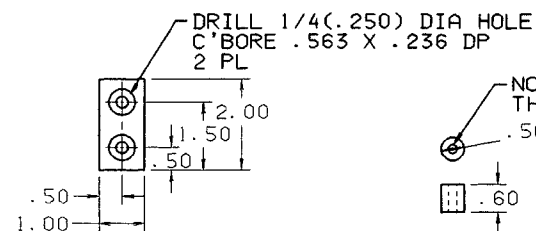
ORIGINAL

MS SH8767SW

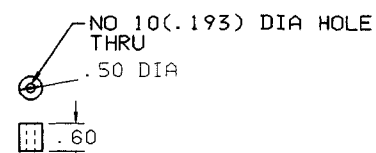




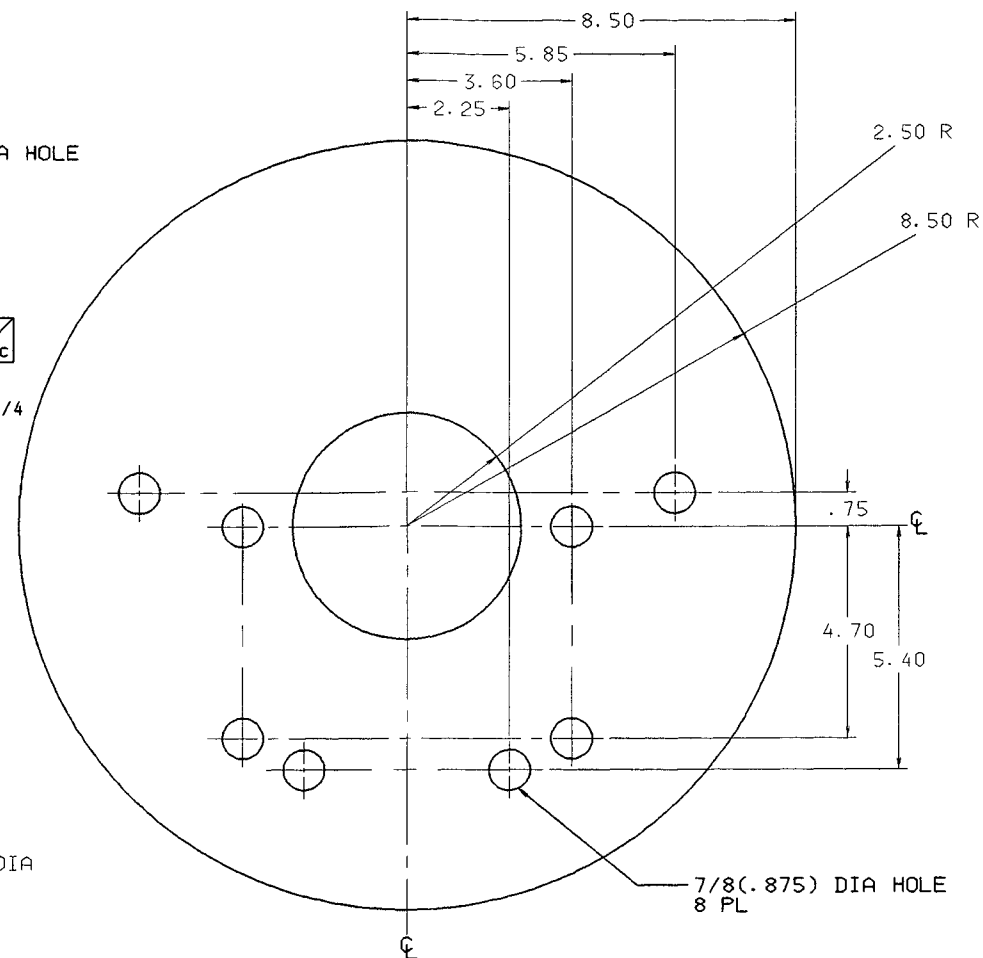
**-131 SLEEVE**   
MATL: 1.00 THK 17-4 SS  
AMS-5643 COND-H-1075



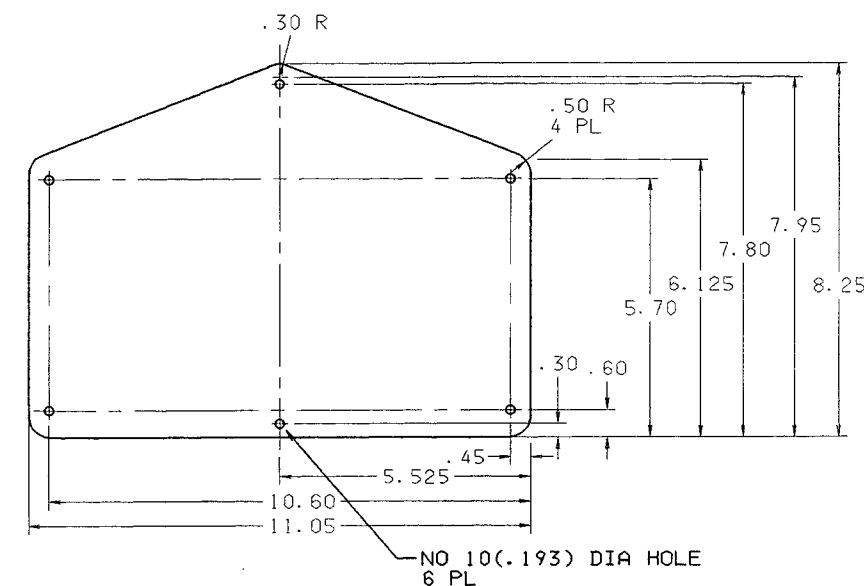
**-133 STOP**   
MATL: .75 THK 2024-T3  
QQ-A-250/4



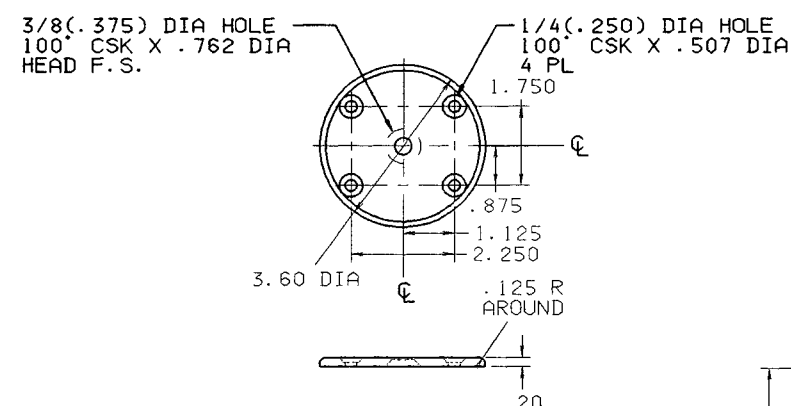
**-139 SPACER**   
MATL: .50 RD STOCK  
2024-T3 QQ-A-250/4



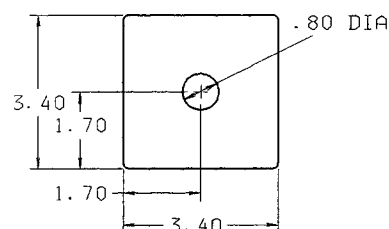
**-145 SLIDE**   
MATL: .25 THK NYLON



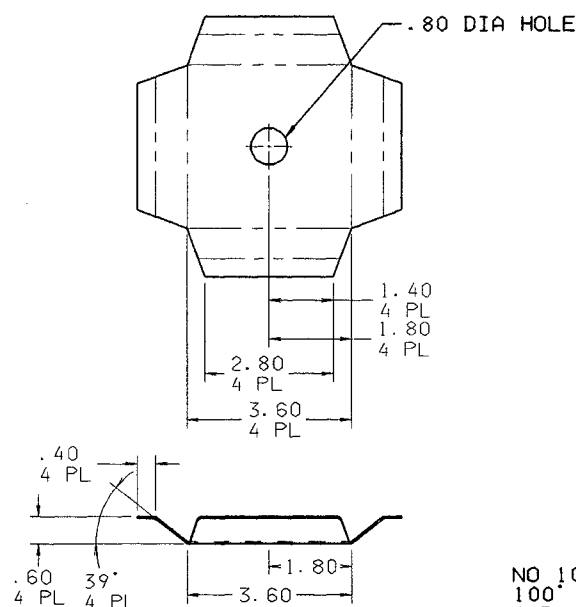
**-151 COVER**   
MATL: 5 PLY FR8600-7781  
FIBERGLASS



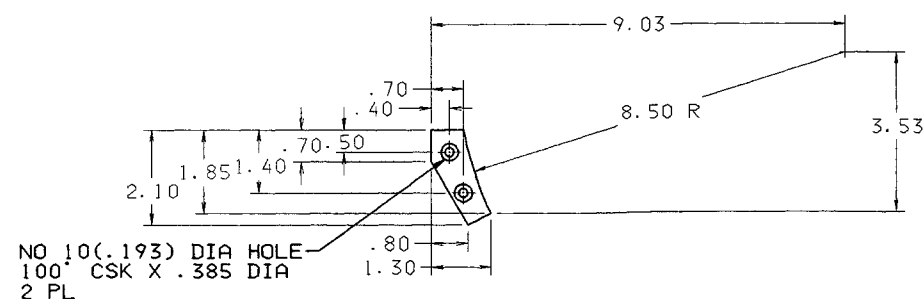
**-135 PLATE**   
MATL: .20 THK 4130 STEEL  
MIL-S-18729 COND N



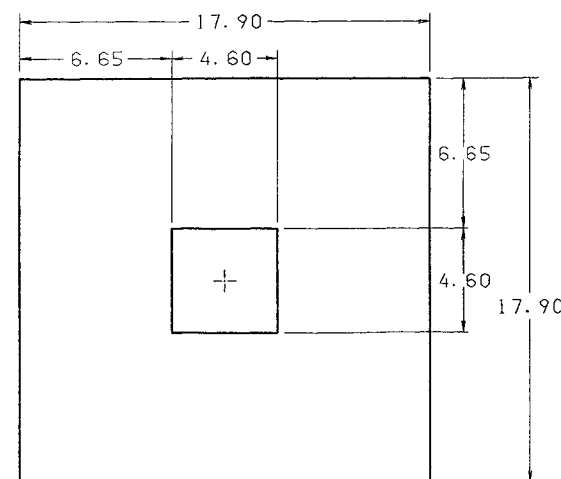
**-141 PLATE**   
MATL: .040 THK 2024-T3  
QQ-A-250/4



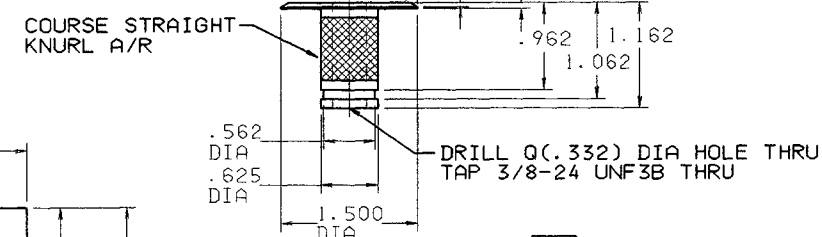
**-137 PLATE**   
MATL: .040 THK 2024-T3  
QQ-A-250/4



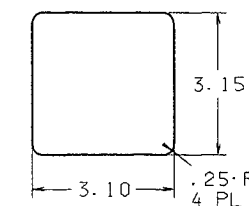
**-143 STOP**   
**-144 STOP (OPP -143)**   
MATL: .20 THK 304SS  
1/4 HARD MIL-S-5059



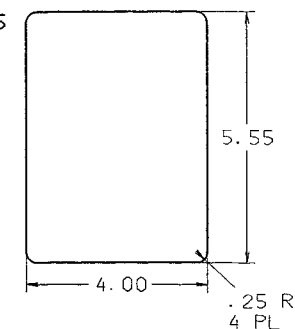
**-147 DOUBLER**   
MATL: .020 THK 2024-T3  
QQ-A-250/4



**-149 INSERT**   
MATL: 1.50 RD STOCK  
17-4PH SS  
AMS-5643 COND-H-1075



**-153 COVER**   
MATL: 5 PLY FR8600-7781  
FIBERGLASS



**-155 COVER**   
MATL: 5 PLY FR8600-7781  
FIBERGLASS

SIZE CODE IDENT NO.	REV
D OSUV8 B89-23000	A
LITTER ASSY/DETAILS	SHEET 19 OF 25

STC'd PRINT 2B8923000.19

ORIGINAL

STC SH8767SW

-157 TUBE  
MATL: 1.00 X .50 X .065 TUBE  
6061-T6 WW-T-700/6

-159 TUBE  
MATL: 1.00 X .50 X .065 TUBE  
6061-T6 WW-T-700/6

-161 TUBE  
MATL: 1.00 X .50 X .065 TUBE  
6061-T6 WW-T-700/6

-163 TUBE  
MATL: 5/16 DIA X .035 WALL  
304 SS 1/4 HARD  
MIL-S-5059

-167 TUBE  
MATL: .75 DIA X .050 WALL  
6061-T6 WW-T-700/6

-169 TUBE  
MATL: .65 DIA X .050 WALL  
TEFLON TUBE

-165 TUBE  
MATL: .250 DIA X .049 WALL  
304 SS 1/4 HARD  
MIL-S-5059

-171 PLATE  
MATL: .040 THK 6061-T6  
QQ-A-250/11

-173 TUBE  
MATL: .65 DIA X .050 WALL  
TEFLON TUBE

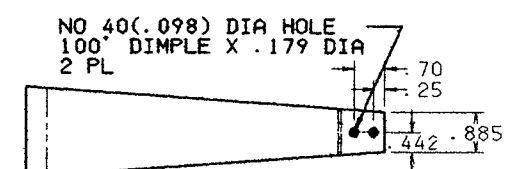
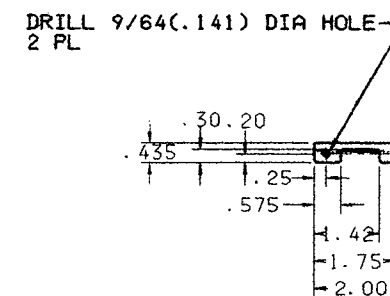
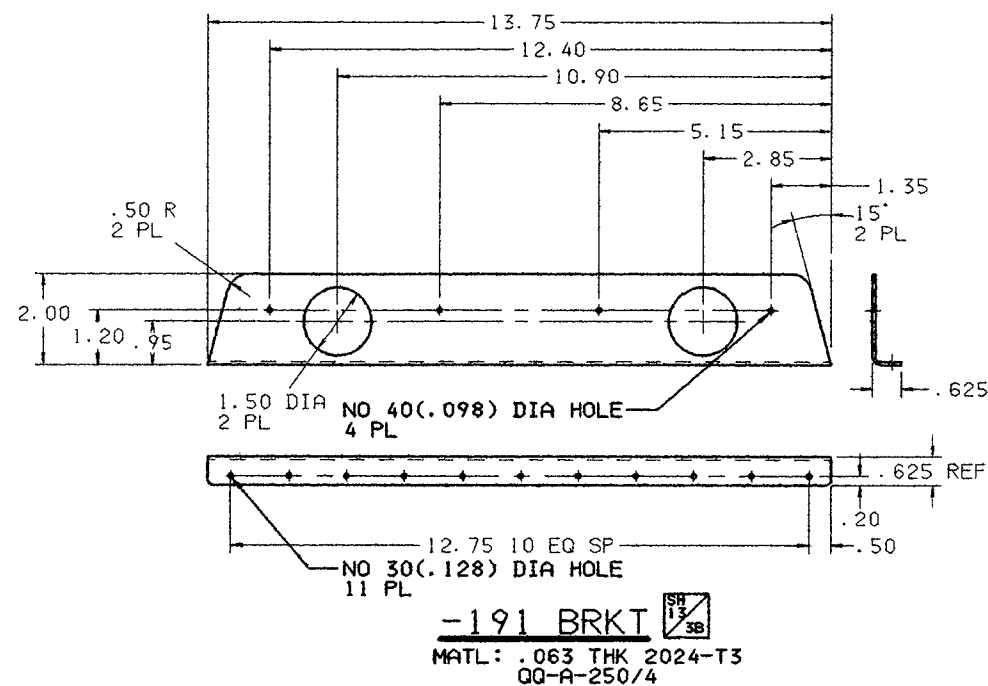
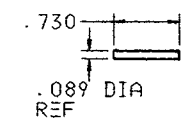
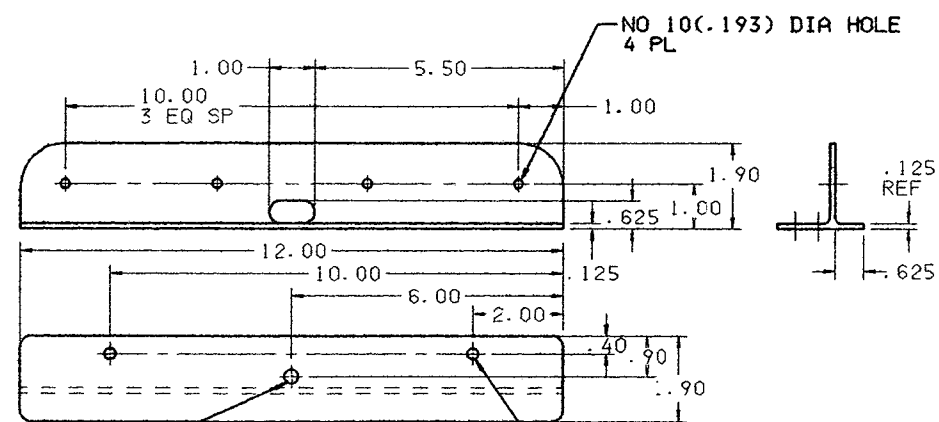
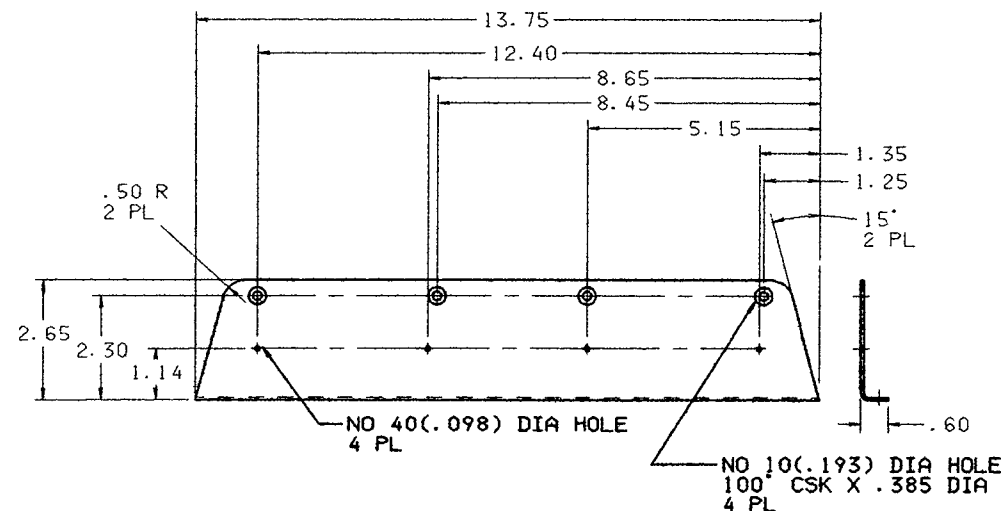
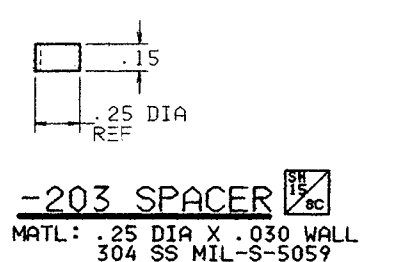
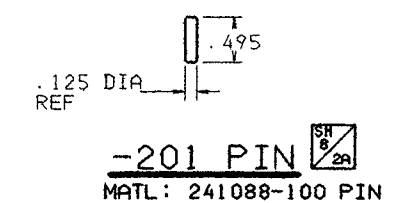
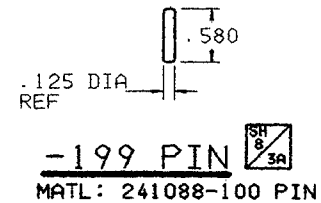
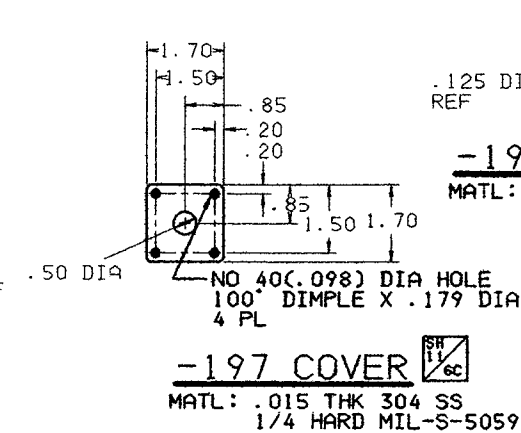
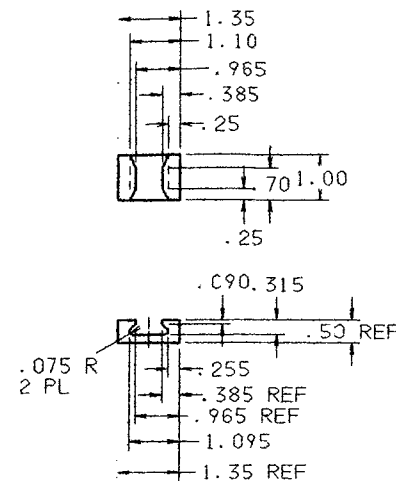
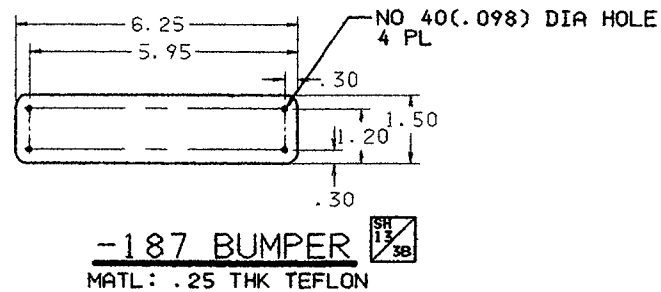
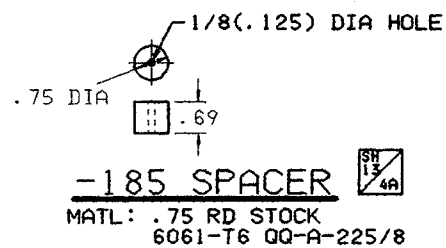
-175 PLATE  
MATL: .015 THK 1/4 HARD  
304 SS MIL-S-5059

-177 HANDLE  
MATL: 1.00 THK 6061-T651  
QQ-A-250/11

-179 TUBE  
MATL: 5/16 DIA X .035 WALL  
304 SS 1/4 HARD  
MIL-S-5059

-181 TUBE  
MATL: .75 DIA X .050 WALL  
6061-T6 WW-T-700/6

-183 PLATE  
MATL: .040 THK 6061-T6  
QQ-A-250/11



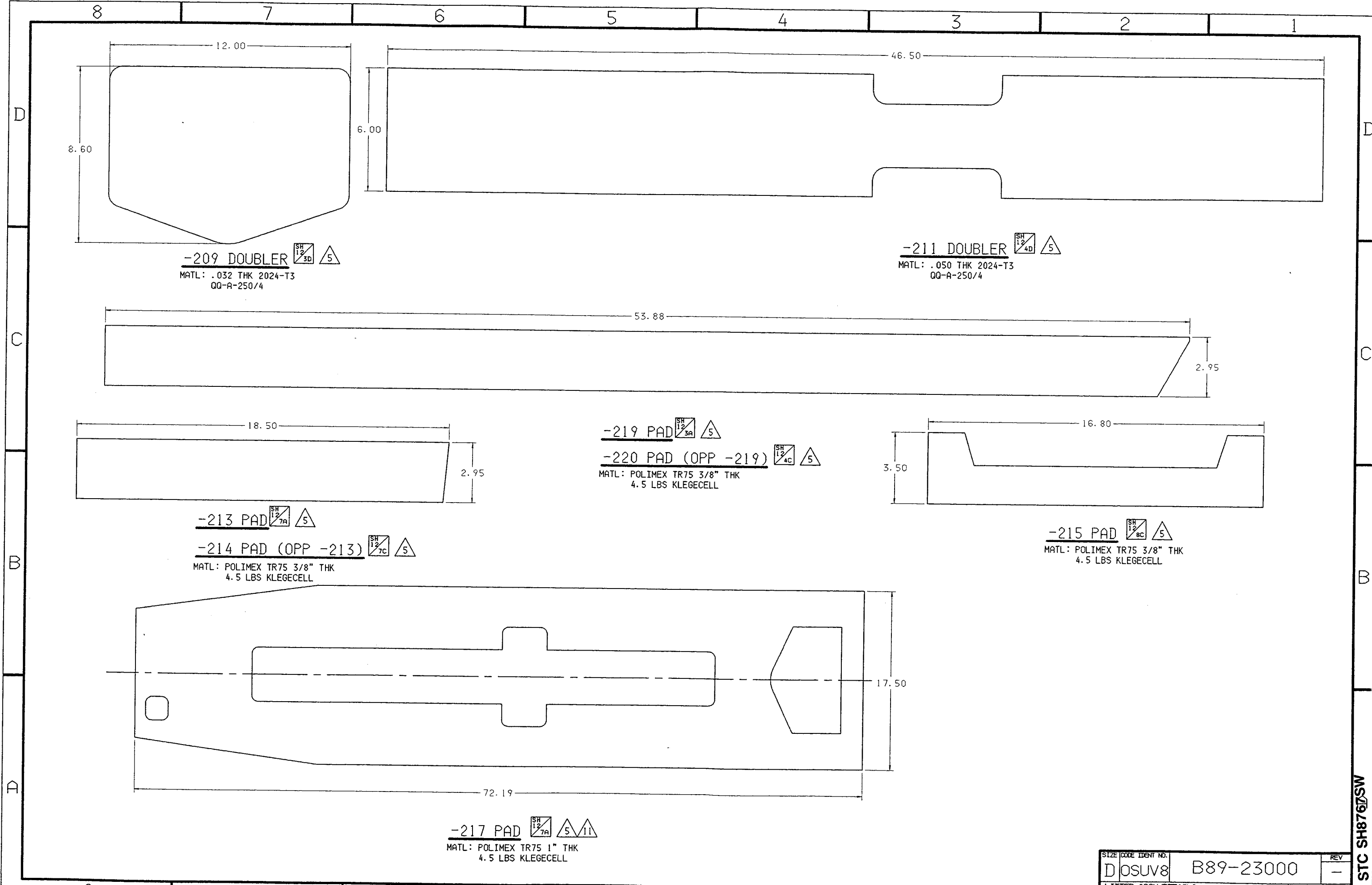
SIZE CODE IDENT NO.	REV
DOSUV8	A
LITTER ASSY/DETAILS	

B89-23000  
 2B8923000, 21  
 SHEET 21 OF 25

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STC SH87B7SW



SIZE CODE IDENT NO.	REV
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LITTER ASSY/DETAILS	SHEET 22 OF 25

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ORIGINAL

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8 7 6 5 4 3 2 1

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C

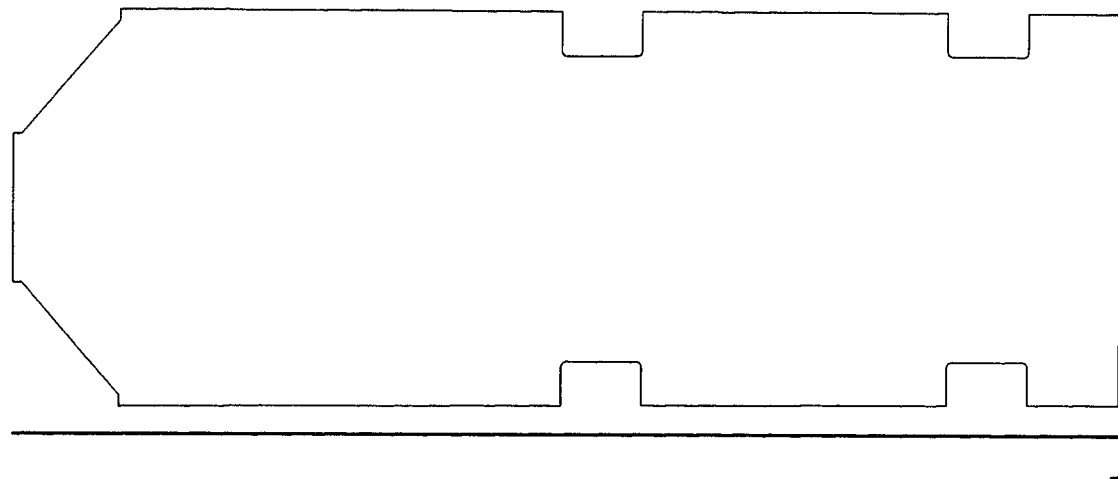
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B

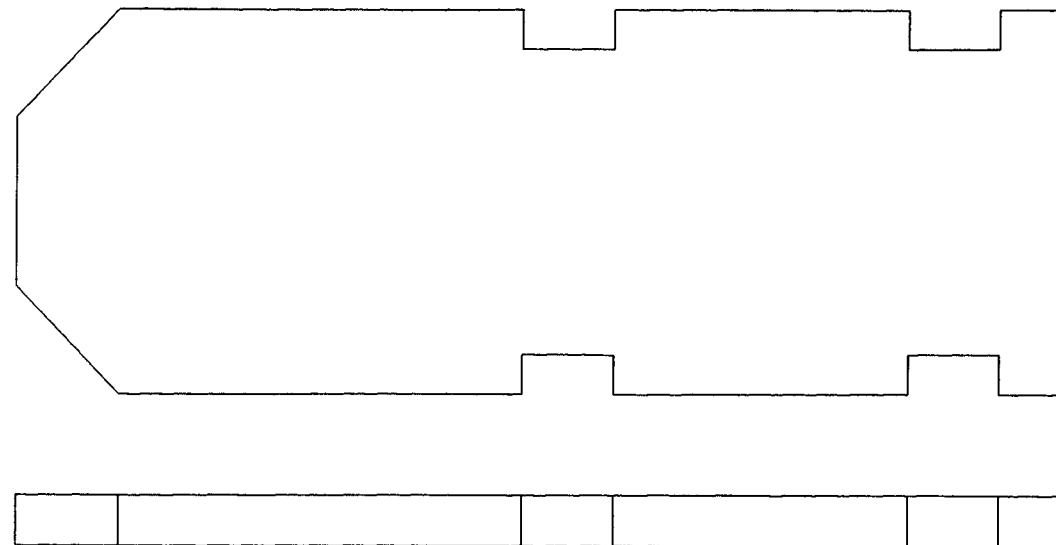
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A

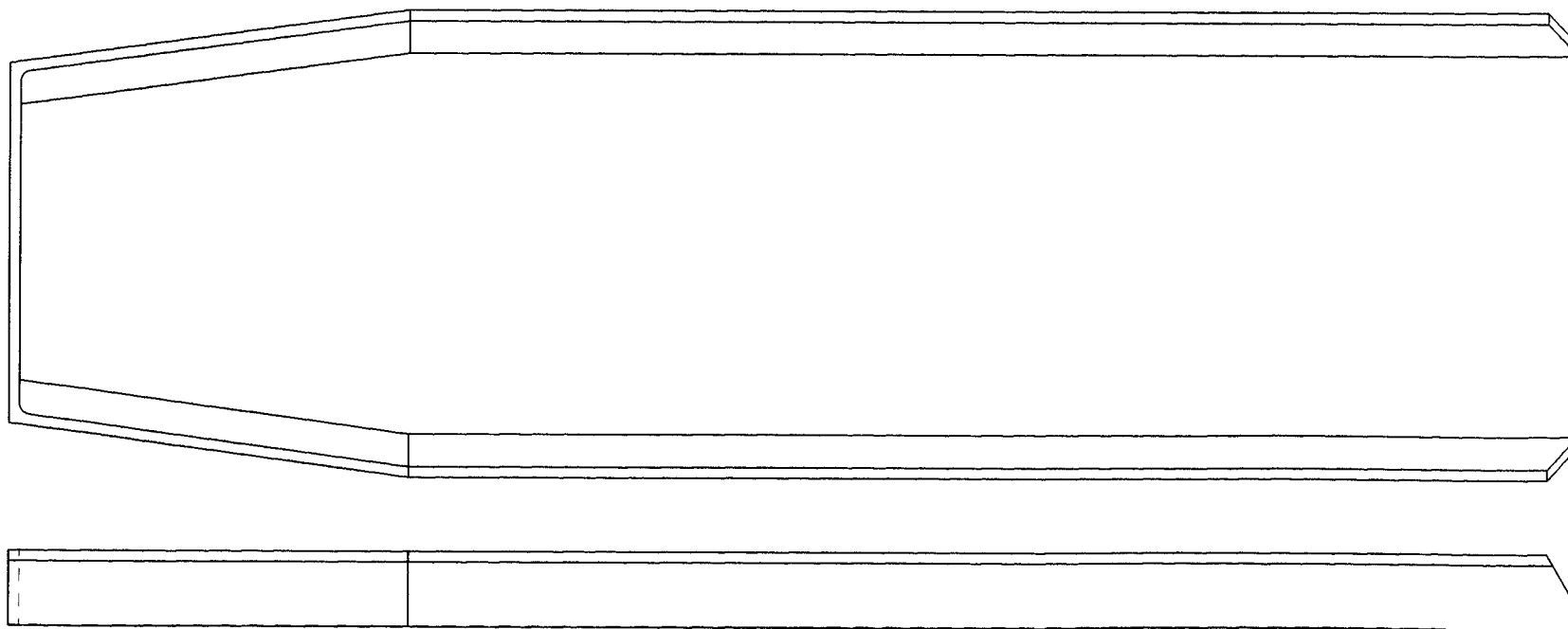
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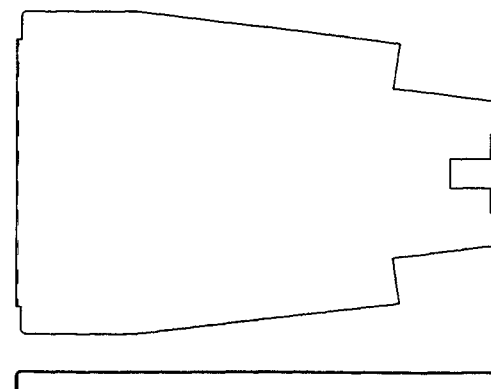
-293 SKIN    
MATL: .063 THK 2024-T0  
QQ-A-250/4





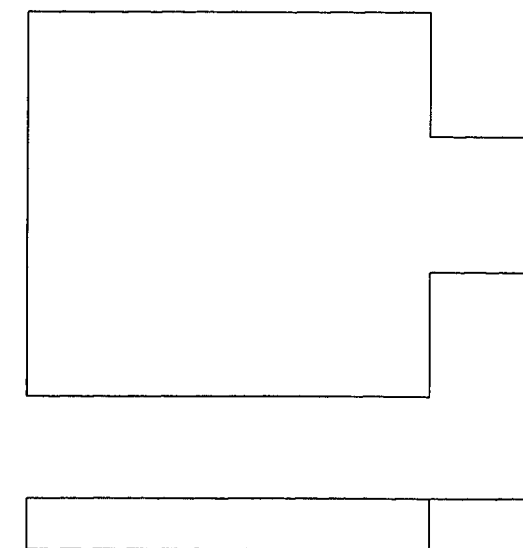
-297 PAD     
MATL: 3" THK FOAM  
(AMERICAN FOAM)



-221 FLUID FLOOR     
MATL: .060 THK KYDEX 100  
COLOR #0327B  
TEXTURE P-5

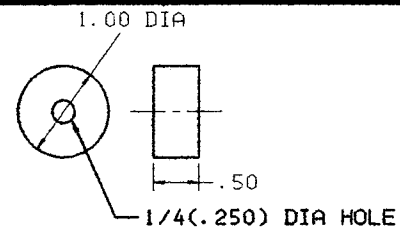


-291 SKIN    
MATL: .063 THK 2024-T0  
QQ-A-250/4

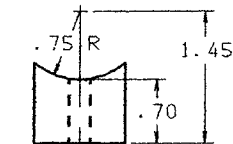


-295 PAD     
MATL: 3" THK FOAM

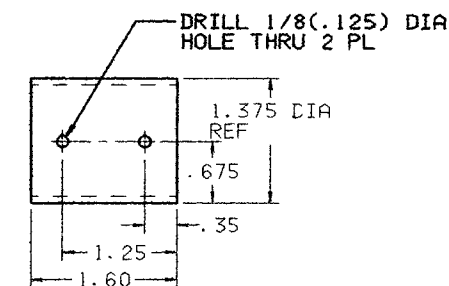
SIZE	CODE	IDENT NO.	REV
D	OSUV8	B89-23000	A
LITTER ASSY/DETAILS			SHEET 23 OF 25



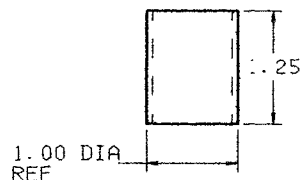
**-227 WHEEL**   
MATL: 1.00 DIA X .50THK  
NYLATRON G.S.



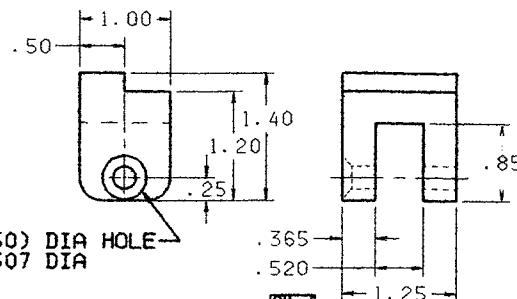
**-229 BRKT**   
MATL: 1.00 THK 6061-T6511  
QQ-A-200/8  
DRILL NO 3(.213) DIA HOLE THRU  
TAP 1/4-28UNF-3B THRU



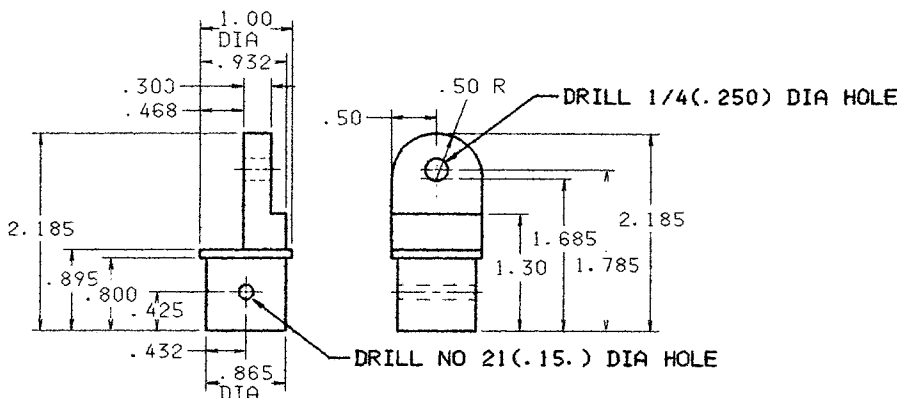
**-231 TUBE**   
MATL: 1.375 DIA X .057 WALL  
4130 STEEL MIL-S-18729  
COND N



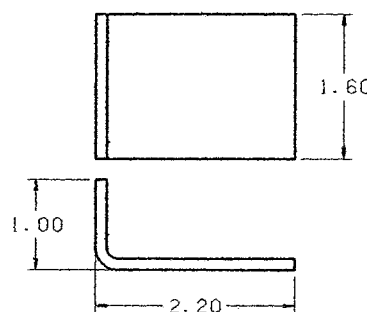
**-233 TUBE**   
MATL: 1.25 DIA X .050 WALL  
4130 STEEL MIL-S-18729  
COND N



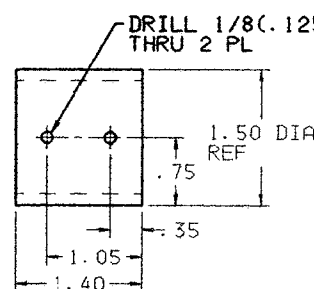
**-235 BRKT**   
**-236 BRKT (OPP -235)**   
MATL: 1.50 THK 6061-T6511  
QQ-A-200/8



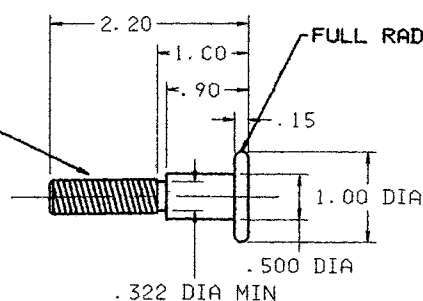
**-237 BRKT**   
MATL: 1.00 THK 6061-T6511  
QQ-A-200/8



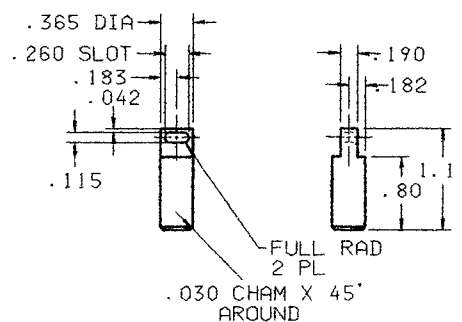
**-239 BRKT**   
MATL: .125 THK 4130 STEEL  
MIL-S-18729 COND N



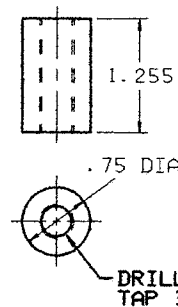
**-245 TUBE**   
MATL: 1.50 DIA X .125 WALL  
6061-T6 WW-T-700/6



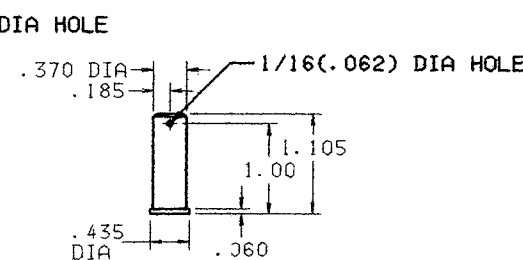
**-247 STUD**   
MATL: 1.00 RD STOCK  
303 SS MIL-S-5059



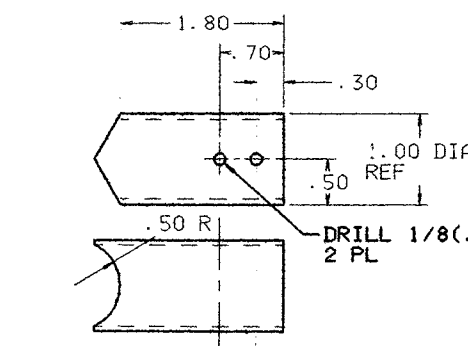
**-241 PIN**   
MATL: .375 DIA 303 SS  
MIL-S-5059



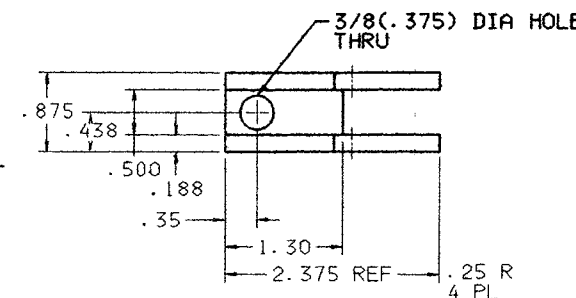
**-243 PIN**   
MATL: .750 DIA 6061-T6511  
QQ-A-200/8



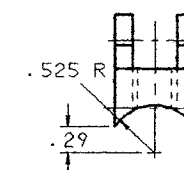
**-251 PIN**   
MATL: .500 DIA 6061-T6511  
QQ-A-200/8



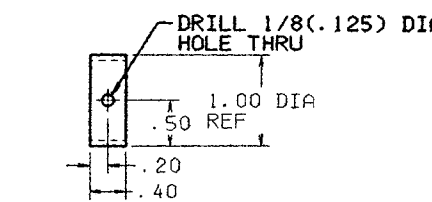
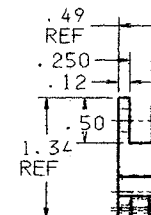
**-249 TUBE**   
MATL: 1.00 DIA X .050 WALL  
6061-T6 WW-T-700/6



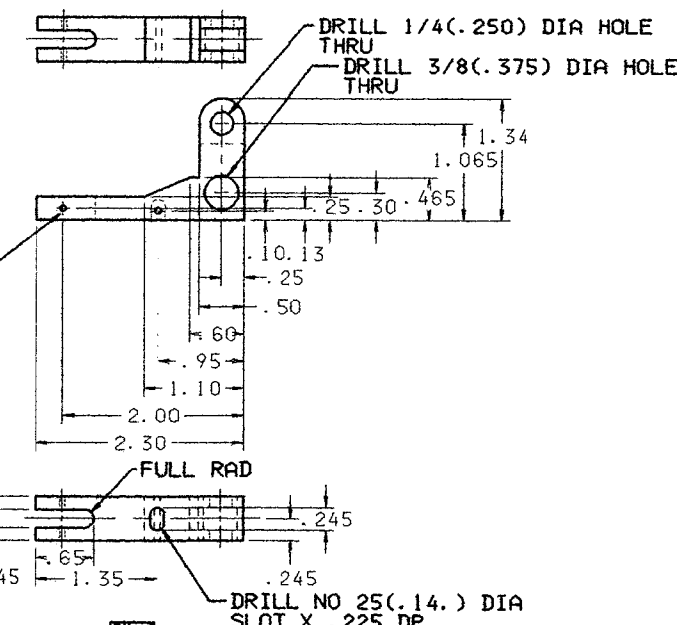
**-255 TUBE**   
MATL: 1.00 DIA X .050 WALL  
6061-T6 WW-T-700/6



**-257 BRKT**   
MATL: 1.50 THK 6061-T6511  
QQ-A-200/8

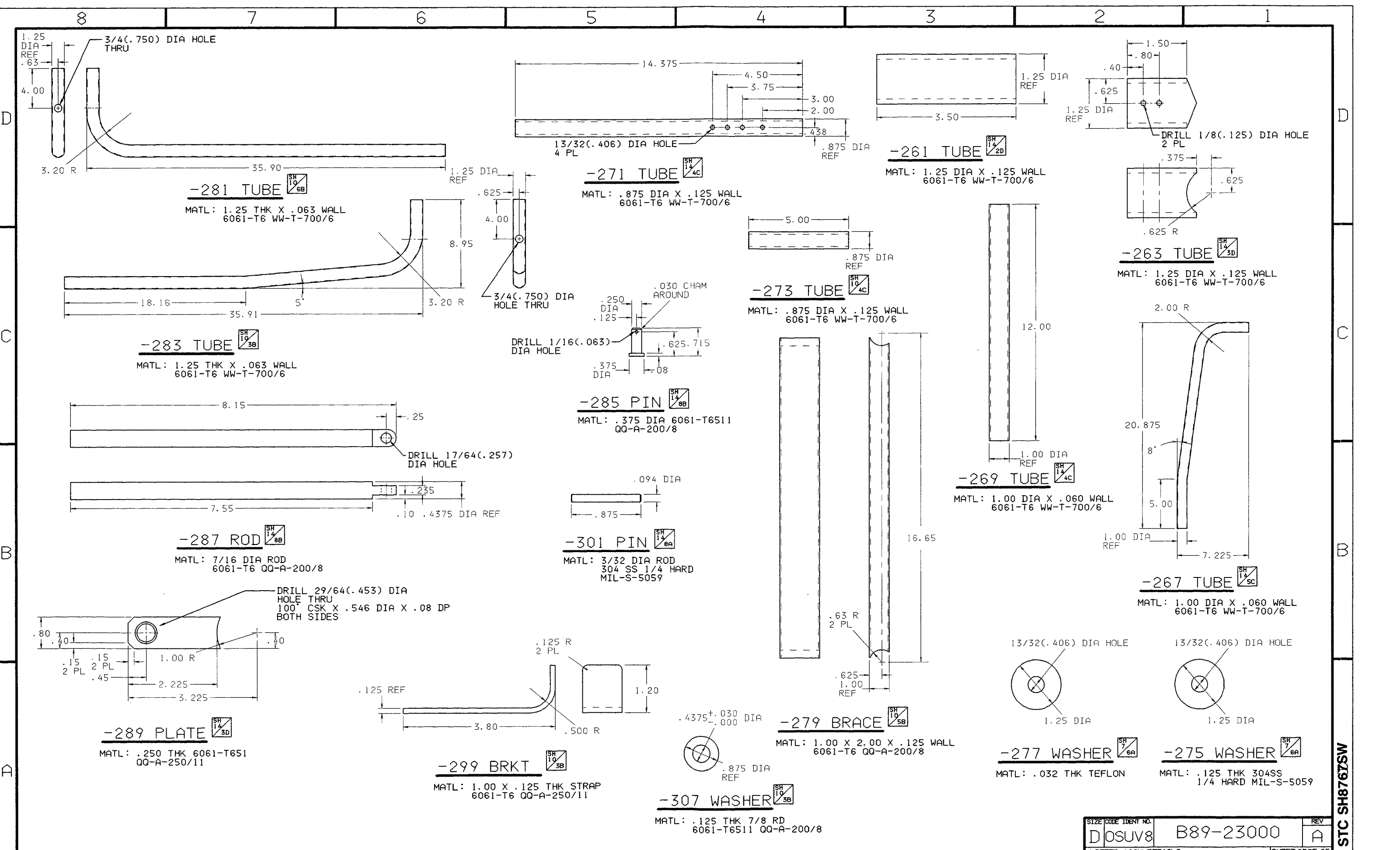


**-253 TUBE**   
MATL: 1.00 DIA X .050 WALL  
6061-T6 WW-T-700/6



**-259 BRKT**   
MATL: 1.50 THK 6061-T6511  
QQ-A-200/8





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